



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D205-633-011
Job Sheet 185980



Part No: D205-633-011

Job Qty: 4 ea ³

Part Name: Heli-Access-Step™ - High Gear, Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/7/18

Job Tracking No:

Due Date: 11/27/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEET 17 IPP Rev:F 02.07.11 Reformat; Removed D3010 RF

Ship Via: ⁶⁴⁵⁸

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time		
90	Start up Operation	4 Ea	11/27/18	11/27/18	0.00	0.00	Start Up Stores/Pkg-1	6	NOV 14 2018	
110	Packaging	4 pcs	11/27/18	11/27/18	0.00	0.00	Packaging1-2	2-89	NOV 21 2018	
120	QC	4 pcs	11/27/18	11/27/18	0.00	0.00	QC4			
130	Packaging	4 pcs	11/27/18	11/27/18	0.00	0.00	Packaging3-1			
135	DC	4 pcs	11/27/18	11/27/18	0.00	0.00	DC			
140	QC21-FG	4 Ea	11/27/18	11/27/18	0.00	0.00	QC21			

Part Op 130 - Identify and pack for shipping as per PPP D205-633-011 Location:FG082
Descriptions: 135 - Photocopy bluefile & type labels per PPP205-633-011 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-14A	Bolt	4 Ea (1 ea)	90-Start up Operation	5114981
AN4-5A	Bolt	8 Ea (2 ea)	90-Start up Operation	5089315
AN4-6A	Bolt	8 Ea (2 ea)	90-Start up Operation	5053445
AN4-7A	Bolt	8 Ea (2 ea)	90-Start up Operation	5051520
AN5-14A	Bolt	4 Ea (1 ea)	90-Start up Operation	5056344
AN5-6A	Bolt	4 Ea (1 ea)	90-Start up Operation	5103251
D2021-101	Eyebolt	4 Ea (1 ea)	90-Start up Operation	5043119
D2022-101	Spacer	8 Ea (2 ea)	90-Start up Operation	5124033
D2022-103	Spacer	8 Ea (2 ea)	90-Start up Operation	5109816x5 512 6068x8
D2562-001	Strut 19.68"	4 Ea (1 ea)	90-Start up Operation	5116748x3 51245231
D2565-101	Strut	4 Ea (1 ea)	90-Start up Operation	5116748x1 5122776x3
D2565-103	Strut	4 Ea (1 ea)	90-Start up Operation	5116748x1 5122956
D2565-105	Strut	4 Ea (1 ea)	90-Start up Operation	511119x1 5122958x
D2565-107	Strut	4 Ea (1 ea)	90-Start up Operation	5111360x3 5123322x1
D2565-109	Strut	4 Ea (1 ea)	90-Start up Operation	5111360x2 5123483x1
D2565-111	Strut	4 Ea (1 ea)	90-Start up Operation	5111360x2 5123574x1
MS21042L4	Nut	32 Ea (8 ea)	90-Start up Operation	5127433x1 5108736x2
MS21042L5	Nut	8 Ea (2 ea)	90-Start up Operation	5127433x1 5093598
NAS1149D0463J	Washer	60 Ea (15 ea)	90-Start up Operation	5127434x1 5092780x
NAS1149D0563J	Washer	16 Ea (4 ea)	90-Start up Operation	5050053
D2563	Step Weldment Assembly	4 Ea (1 ea)	110-Packaging	5125831



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
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Container No: S127563



Part: D205-633-011

Job No: 185980

Serial No/Batch: S127563

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH96-57 Issue 5, FAA STC SR005921

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40, 11 2006

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-14A	4	1,033	0
	AN4-5A	8	174	0
	AN4-6A	8	726	0
	AN4-7A	8	196	0
	AN5-14A	4	51	0
	AN5-6A	4	88	0
	D2021-101	4	18	0
	D2022-101	8	60	0
	D2022-103	8	65	0
	D2562-001	4	7	0
	D2565-101	4	7	0
	D2565-103	4	7	0
	D2565-105	4	7	0
	D2565-107	4	9	0
	D2565-109	4	8	0
	D2565-111	4	8	0
	MS21042L4	32	2,463	0
	MS21042L5	8	471	0
	NAS1149D0463J	60	3,231	0
	NAS1149D0563J	16	1,404	0
	D2563	4	4	0
110-Packaging				

Part Specifications

Specifications could not be found.



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90	Start up Operation	2 Ea		11/27/18	0.00	0.00	Start Up Stores/Pkg-1		
110	Packaging	2 pcs		11/27/18	0.00	0.00	Packaging1-2		
120	QC	2 pcs		11/27/18	0.00	0.00	QC4		
130	Packaging	2 pcs		11/27/18	0.00	0.00	Packaging3-1		
135	DC	2 pcs		11/27/18	0.00	0.00	DC		
140	QC21-FG	2 Ea		11/27/18	0.00	0.00	QC21		

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-14A	Bolt	2 Ea (1 ea)	90-Start up Operation	
AN4-5A	Bolt	4 Ea (2 ea)	90-Start up Operation	
AN4-6A	Bolt	4 Ea (2 ea)	90-Start up Operation	
AN4-7A	Bolt	4 Ea (2 ea)	90-Start up Operation	
AN5-14A	Bolt	2 Ea (1 ea)	90-Start up Operation	
AN5-6A	Bolt	2 Ea (1 ea)	90-Start up Operation	
D2021-101	Eyebolt	2 Ea (1 ea)	90-Start up Operation	
D2022-101	Spacer	4 Ea (2 ea)	90-Start up Operation	
D2022-103	Spacer	4 Ea (2 ea)	90-Start up Operation	
D2562-001	Strut 19.68"	2 Ea (1 ea)	90-Start up Operation	
D2565-101	Strut	2 Ea (1 ea)	90-Start up Operation	
D2565-103	Strut	2 Ea (1 ea)	90-Start up Operation	
D2565-105	Strut	2 Ea (1 ea)	90-Start up Operation	
D2565-107	Strut	2 Ea (1 ea)	90-Start up Operation	
D2565-109	Strut	2 Ea (1 ea)	90-Start up Operation	
D2565-111	Strut	2 Ea (1 ea)	90-Start up Operation	
MS21042L4	Nut	16 Ea (8 ea)	90-Start up Operation	
MS21042L5	Nut	4 Ea (2 ea)	90-Start up Operation	
NAS1149D0463J	Washer	30 Ea (15 ea)	90-Start up Operation	
NAS1149D0563J	Washer	8 Ea (4 ea)	90-Start up Operation	
D2563	Step Weldment Assembly	2 Ea (1 ea)	110-Packaging	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-14A	2	1,117	0
	AN4-5A	4	180	0
	AN4-6A	4	934	0
	AN4-7A	4	196	0
	AN5-14A	2	51	0
	AN5-6A	2	88	0
	D2021-101	2	18	0
	D2022-101	4	0	0
	D2022-103	4	5	0
	D2562-001	2	7	0
	D2565-101	2	7	0
	D2565-103	2	7	0
	D2565-105	2	7	0
	D2565-107	2	9	0
	D2565-109	2	8	0
	D2565-111	2	8	0
	MS21042L4	16	3,021	0
	MS21042L5	4	475	0
	NAS1149D0463J	30	3,917	0
	NAS1149D0563J	8	1,412	0
110-Packaging	D2563	2	0	0

Part Specifications

Specifications could not be found.

Plex 11/7/18 2:58 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coor. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐																						
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Description Work Order Deviation				Disposition				Completed By																	
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Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :																							
Misidentified ☐	Past Due ☐																								

5.0 PARTS LISTS

5.1 D205-633-011/-013/-015/-017 Heli-Access Step

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				D205-633-011	Heli-Access-Step™, High Gear
	X			D205-633-013	Heli-Access-Step™, Extended High Gear (31")
		X		D205-633-015	Heli-Access-Step™, Extended High Gear (39")
			X	D205-633-017	Heli-Access-Step™, Standard Low Gear
1			1	D2021-101	EYEBOLT
2	2	2	2	D2022-101	SPACER
2	2	2	2	D2022-103	SPACER
1				D2562-001	STRUT
		1		D2562-005	STRUT
			1	D2562-007	STRUT
	1			D2562-013	STRUT
1	1	1	1	D2563	WELDMENT ASSEMBLY
1				D2565-101	STRUT
1				D2565-103	STRUT
1				D2565-105	STRUT
1				D2565-107	STRUT
1				D2565-109	STRUT
1				D2565-111	STRUT
	1			D2565-201	STRUT
	1			D2565-203	STRUT
	1			D2565-205	STRUT
	1			D2565-207	STRUT
	1			D2565-209	STRUT
	1			D2565-211	STRUT
		1		D2565-301	STRUT
		1		D2565-303	STRUT
		1		D2565-305	STRUT
		1		D2565-307	STRUT
		1		D2565-309	STRUT
			1	D2565-401	STRUT
			1	D2565-403	STRUT
			1	D2565-405	STRUT
			1	D2565-407	STRUT
			1	D2565-409	STRUT
			1	D2565-411	STRUT
		1		D3165-1	SUPPORT ARM
	1	1		AN44-7A	EYEBOLT
2	1	1	2	AN4-5A	BOLT
2	3	3	2	AN4-6A	BOLT
2	2	2	2	AN4-7A	BOLT
1	1	1	1	AN4-14A	BOLT
	1	1		AN4-10A	BOLT
1			1	AN5-6A	BOLT
1	1	1	1	AN5-14A	BOLT
15	16	16	15	AN960JD416	WASHER
4	3	3	4	AN960JD516	WASHER
8	8	8	8	MS21042L4	NUT (or MS21042-4)
2	2	2	2	MS21042L5	NUT (or MS21042-5)

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Revision: C

Date: 13.12.13

Change Record

PAGE 1 OF 1

Part Number: D205-633-011/-017

Description: HELI-ACCESS STEP, HIGH GEAR / STANDARD LOW GEAR

[illegible]

